

Machine	Mikron VCP 600
Spindle type	Step-Tec
Max RPM	20.000
Power Kw	18 Kw
Cutter holder	Collet Chuck
Workpiece material	Acryl - PMMA
Hardness	
Application	
Side milling	<input checked="" type="checkbox"/> Up-milling <input type="checkbox"/>
Slotting	<input type="checkbox"/> Down-milling <input type="checkbox"/>
Profiling	<input type="checkbox"/> Ramping <input type="checkbox"/>
Plunging	<input checked="" type="checkbox"/> Circular <input checked="" type="checkbox"/>



Cutter supplier	
Cutter description	
Cutter diameter eff.	Ød mm
Number of teeth	z
Carbide grade	

van Hoorn Carbide	van Hoorn Carbide
VHKE 1 080 060 08 10 L160	VHKE 1 080 060 08 10 L160
8	8
1	1
10	10

Cutting conditions	
Cutting speed	V _c m/min
Revolution	n rpm
Feed per tooth	f _z mm
Table feed	V _f mm/min
Depth of cut	a _p mm
Width of cut	a _e mm
Length of cut	L mm
Chip removal rate	Q cm ³ /min
Chip thickness	H _m mm
Coolant type	
Coolant pressure	Bar
Cutting time / comp	T _{comp} min
Toollife	T _{total} min
Power consumption	P Kw
Edge wear	V _b mm

450	450
17.905	17.905
0,050	0,028
895	500
15	10
4	10
53,70	50,00
0,03535	0,03122
dry / air / minimum lub. / emulsion	dry / air / minimum lub. / emulsion
Internal External	Internal External

Remarks

Test 1: Sidemilling. Most important is the quality of the surface, which is very smooth.
 Test 2: Plunging. total depth is 10 mm. Plunging steps are 1 mm. Surface is also very smooth.